

Date: Thursday, 13/11/2008 1:05:56 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT ASSEMBLY		
Job Number	: 43418			Part Number	: D3278041		
Estimate Number	: 10464			Drawing Number	: D3278 REV.C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 28/11/2008 Qty: 40 Um: Each		
Previous Run	: 42320						
Written By	:						
Checked & Approved By	: JUO 08.11.14						
Comment	: Est:A 04.04.19 New issue KJ/JLM EST B 07.08.21 Chg rivet per PAR185 by: JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	43418A	SUPPORT	<i>08/11/27</i>
			<i>B42320 A 25x B43418A 15x</i>
Comment:	Sub-Component SUPPORT 1 x D3278-1 Batch		
2.0	43418B	SUPPORT	<i>08/11/27</i>
			<i>B42320 B 21x B43418B 19x</i>
Comment:	Sub-Component SUPPORT 1 x D3278-2 Batch		
3.0	D32783	Spacer	<i>08/11/27</i>
			<i>B43448 18</i>
Comment:	Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)		
X	Spacer		
Pick:			
Qty	Part Number	Description	Batch
1	D3278-3	Spacer	<i>B41451 22x</i>
4.0	MS20426AD36	Rivet	<i>08/11/27</i>
			<i>M105055</i>
Comment:	Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)		
RIVET			
Pick:			
Qty	Part Number	Description	Batch
4	MS20426AD3-6	Rivet	<i>M105055</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43418		Part Number: D3278041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
6.0	QC5	INSPECT WORK TO CURRENT STEP Comments: SMALL & MEDIUM FAB RESOURCE 1 Rivet spacers with support as per Dwg D3278. J108/11/27 X40
7.0	D22301	Lug Comments: INSPECT WORK TO CURRENT STEP S 001127 X40
8.0	AN413A	Bolt Comments: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s) Mounting Lug Pick: Packing Kit Qty Part Number Description Batch 2 D2230-1 Mounting Lug 41819 J108/11/28 X40
9.0	AN960JD416	Washer Comments: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 2 AN4-13A Bolt M109285 J108/11/28 X40
10.0	MS21042L4	Nut Comments: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch 4 AN960JD416 Washer M10827 J108/11/28 X40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43418		Part Number: D3278041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041</p> <p><i>8/12/02 40</i></p>		
12.0	QC5 	INSPECT WORK TO CURRENT STEP <i>S 08/12/02 counter 410</i>
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		
13.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>AS 08/12/02 600</i>
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 466</p>		
14.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>08/12/02 AS</i>
Comment: FINAL INSPECTION/W/O RELEASE		<i>MF 08-12-02</i>
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

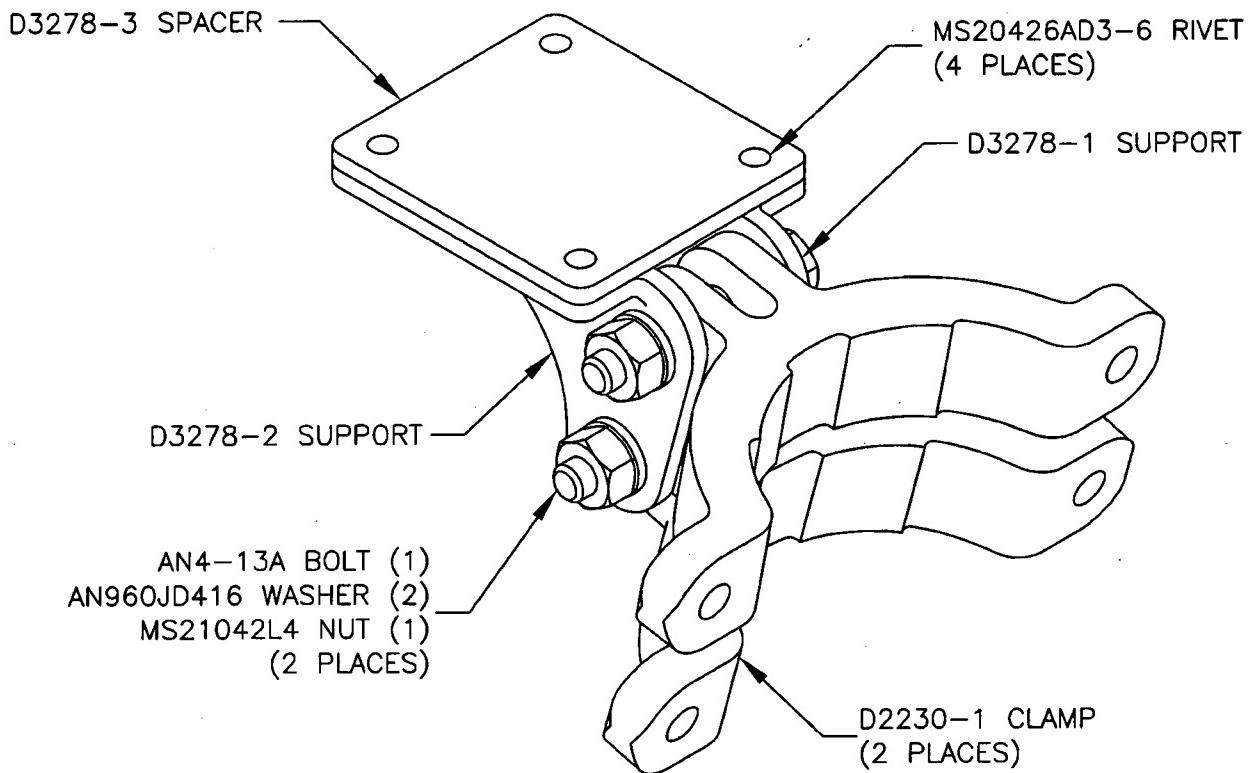
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>AB</i>	DRAWING NO. D3278	REV. C	SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS	
A	04.03.03	NEW ISSUE		
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT		
C	07.07.24	CHANGED RIVETS PER PAR #185		

RELEASED
*07.06.08*D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description	UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <i>43418</i>
X	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

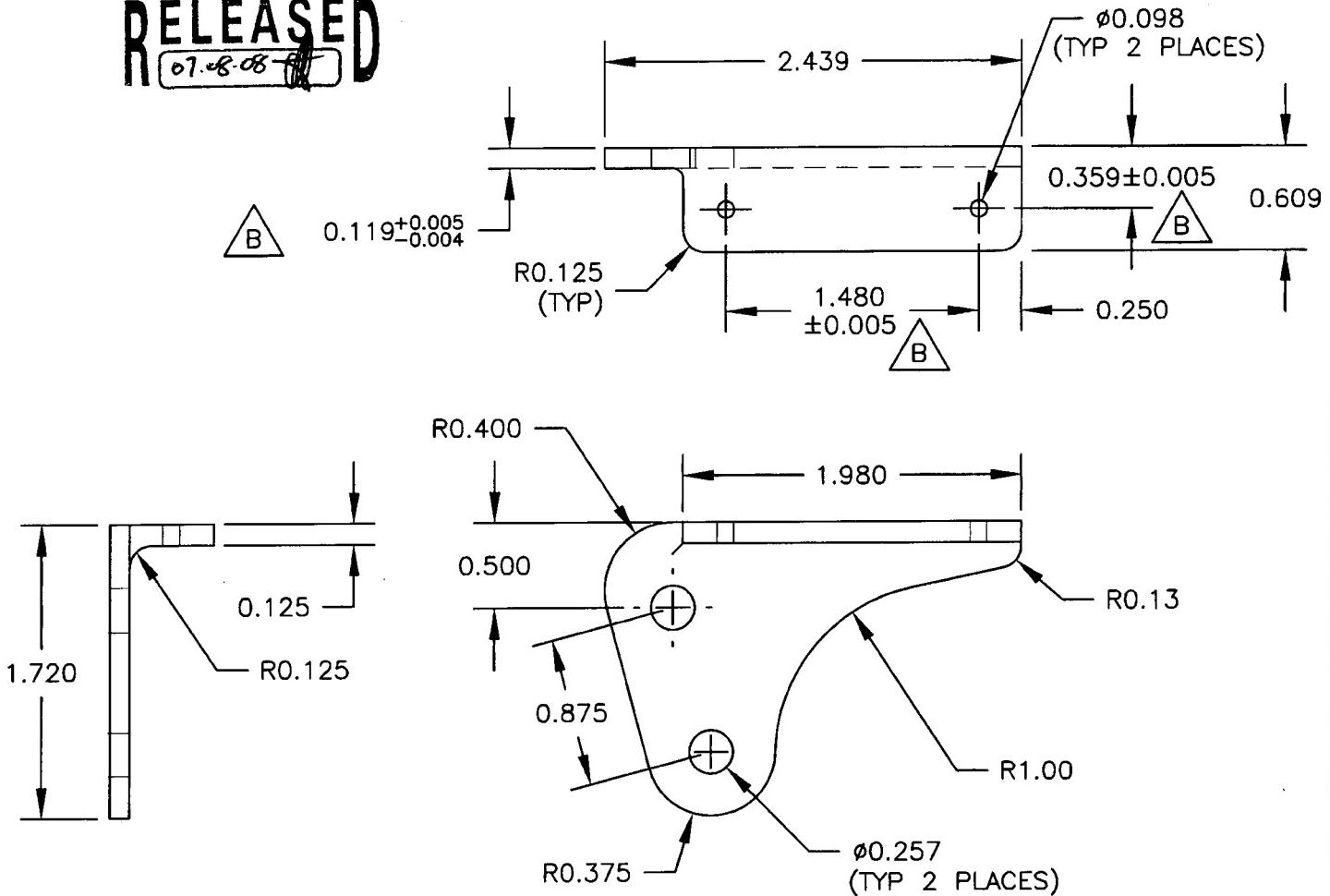
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24		REV. C SHEET 2 OF 3 TITLE SCALE 1:1 SUPPORT ASSEMBLY

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

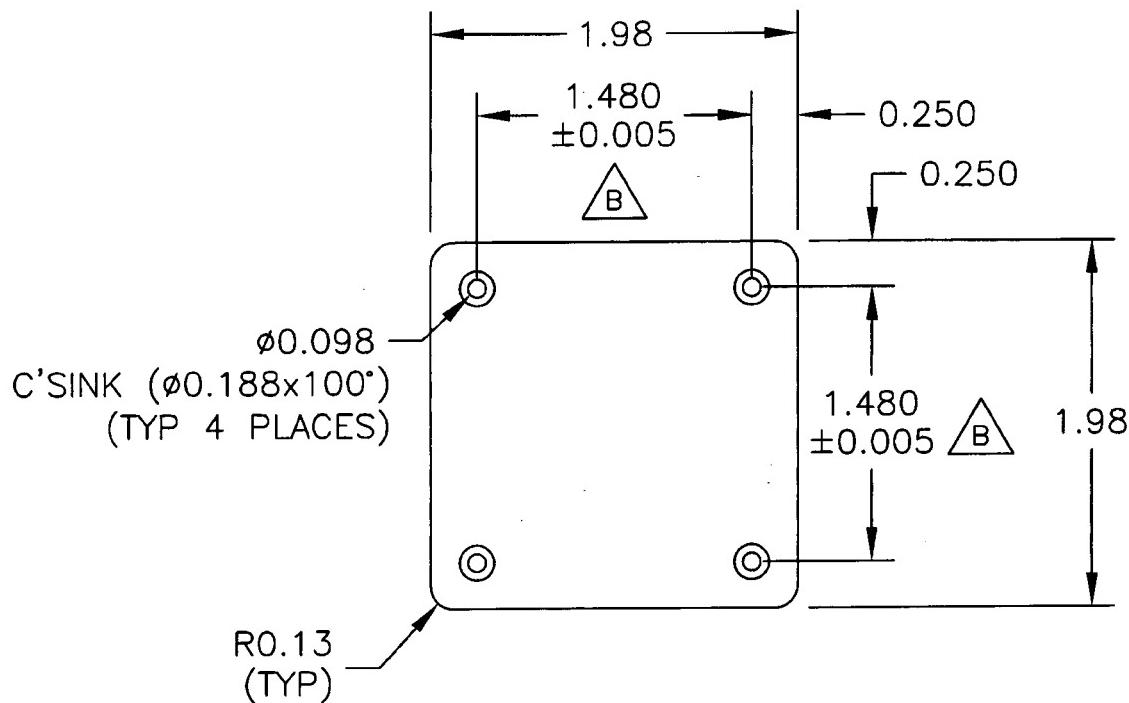
D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 43418

DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>JL</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *43918*

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